

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014275**Date Inspected:** 02-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Chi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

Segment# 7EE ~ 8AE (Joint Survey)

This QA Inspector performed Joint Inspection with ABF Survey Team and ZPMC for the Longitudinal Diaphragm to Longitudinal Diaphragm E3 location (Bike Path side) and E4 Location (Cross Beam Side) for Segment 7EE ~8AE (Shop Segment Splice) between Panel Point (PP) 60 and PP 61. The measured readings were fed in spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Measurement Survey: Longitudinal Diaphragm Offset and Sweep.

Segment # 8CE-PP68

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA inspector observed ZPMC qualified welding personnel identified as 222396 perform Flux Core Arc Welding (FCAW), weld joint identified as SSD27-PP069-027; ZPMC QC is identified as Mr.Feng Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2133. See the attached below Photo.

Segment # 7EE-PP59

This QA inspector observed ZPMC qualified welding personnel identified as 045196 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG041A-004; ZPMC QC is identified as Mr.Feng Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-TC-U4b-FCM-1. See the attached below Photo.

Segment # Cross Beam 8

This QA inspector observed ZPMC qualified welding personnel identified as 220063 perform Flux Core Arc Welding (FCAW), weld joint identified as CB202A-008 and was observed welding in the 2G (horizontal) position; ZPMC QC is identified as Mr.Feng Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2232-TC-U4b-F.

Segment # 7BW-PP50

This QA inspector observed ZPMC qualified welding personnel identified as 066746 perform Flux Core Arc Welding (FCAW), weld joint identified as SEG035E-034 and was observed welding in the 3G (Vertical) position; ZPMC QC is identified as Mr.Feng Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2133.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
